

Date: Friday, 29/08/2008 11:38:33 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
 Job Number : 41671  
 Estimate Number : 10313  
 P.O. Number :  
 This Issue : 29/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D26483  
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D2648 REV D  
 Previous Run : 41611 Project Number : N/A  
 Material :  
 Due Date : 15/09/2008 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08-8-29  
 Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF  
 Est Rev:F Now on Waterjet 06-08-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025 sheet 16GA



Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s)  
 1010/1025/A21/6aA SHEET  
 (M1010S16GA)  
 Batch: 105706 B 8-9-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2648  
 \*\*\*\*\*CUT WITH FILE D2648-1\*\*\*\*\*  
 Dwg Rev: B B 8-9-11  
 Prog Rev: D

(44)

2-Deburr if necessary B 8-9-11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/09/14 SH ccentes

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary

n/a Done at Nov 2008  
508/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 29/08/2008 11:38:34 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41671

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SD 08/09/15

44

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat

M106762

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FL 8-9-16

444

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SD 08/09/16

ccenter

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/09/16

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M106442

START TIME:

10:30 am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:00 am

SD 08-09-17

444

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/09/17

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-17

SD 08-09-17

444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

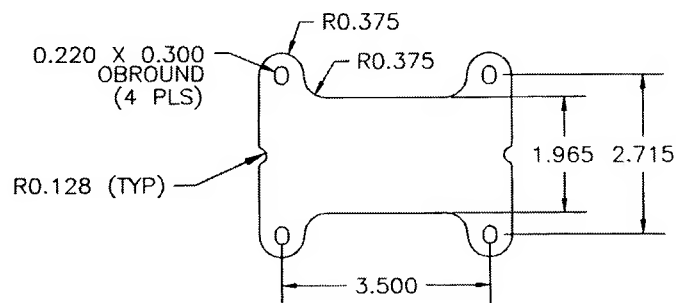
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

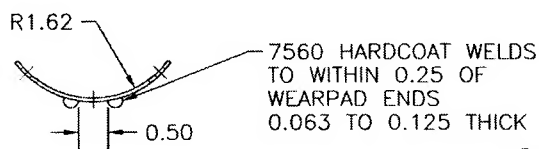
NOTE: Date & initial all entries



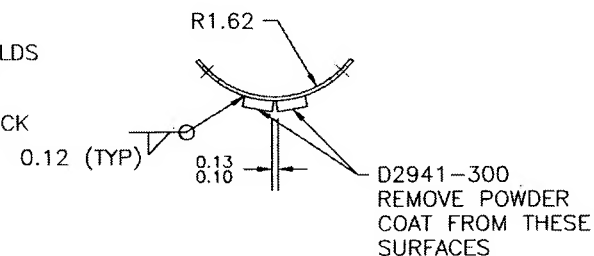
# D2648-1 FLAT PATTERN



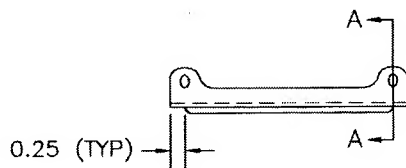
## SECTION A-A



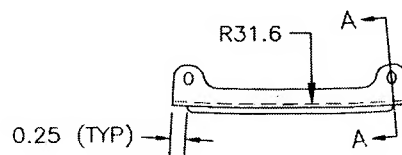
## SECTION B-B



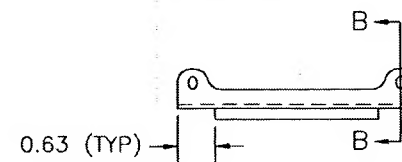
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
14.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	TITLE	WEARPAD
99.11.17		SCALE 1:2

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4167  
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